

Date: Monday, 8/21/2006 2:16:43 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HINGE BRACKET  
 Job Number : 28284  
 Estimate Number : 10349  
 P.O. Number : N/A Part Number : D28582  
 This Issue : 8/21/2006 S.O. No. : N/A Drawing Number : D2858 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B  
 Previous Run : 26036 Material : N/A  
 Due Date : 9/5/2006 Qty: 24 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est C 00.06.22 Removed P/O for powder coat EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1500X01250 6061-T6 Bar 1.5" x 1.25"



Comment: Qty.: 0.1767 f(s)/Unit Total : 4.2412 f(s)  
 Material: 1.50" X 1.25"  
 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)  
 (M6061T6B15001250  
 Batch M1101694

mk 06/08/29: 24

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
 Cut blanks 6.02"  
 Note: 1 Blank Makes 3 Parts

mk 06/08/29 24

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine per folio D2858-2

FE 06/08/20 x24

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

FE 06/08/20 x24

4.1 QCB second check

5.6 06/09/01 24



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-08-31	4.	QC B required for second check. Permanent change					06-08-31

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/09/06

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

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Drawing Name: HINGE BRACKET

Job Number: 28284

Part Number: D28582

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

En 06/08/20<sup>30</sup> x 24

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

06-08-31  
a.m. 06-08-31 (24)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06 08 01 (24)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

06-08-02  
9.m 06-08-02 (24)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/9/05

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51391

06/7/05  
DS 06/09/05 (24)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/06 (24)

Job Completion



06/09/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	28284
<b>Description:</b> Hinge Bracket		<b>Part Number:</b>	D2858-2
<b>Inspection Dwg:</b> D2858	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.000	0.173	/			
Ø0.400	+0.005/-0.000	0.402	/			
R0.125	+/-0.010	0.125	/			
0.328	+/-0.010	0.325	/			
0.820	+/-0.005	0.819	/			
1.476	+/-0.010	1.478	/			
0.342	+/-0.010	0.341	/			
0.875	+/-0.010	0.873	/			
1.56	+/-0.030	1.563	/			
0.147	+/-0.010	0.146	/			
0.717	+/-0.010	0.718	/			
0.697	+/-0.010	0.690	/			
0.229	+/-0.010	0.239	/			
R0.125	+/-0.010	0.125	/			
R0.063	+/-0.010	0.063	/			
0.063	+/-0.010	0.062	/			
0.126	+/-0.010	0.128	/			
0.630	+/-0.010	0.634	/			
R0.354	+/-0.010	0.354	/			
0.965	+/-0.010	0.958	/			
Ø0.166	+0.005/-0.000	0.170	/			

<b>Measured by:</b>	EP	<b>Audited by:</b>	JML	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	06/08/20	<b>Date:</b>	06/08/20	<b>Date:</b>	N/A

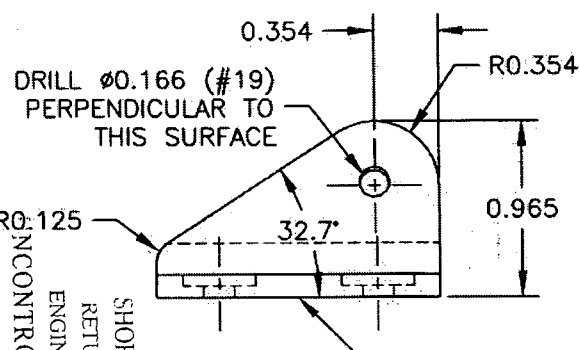
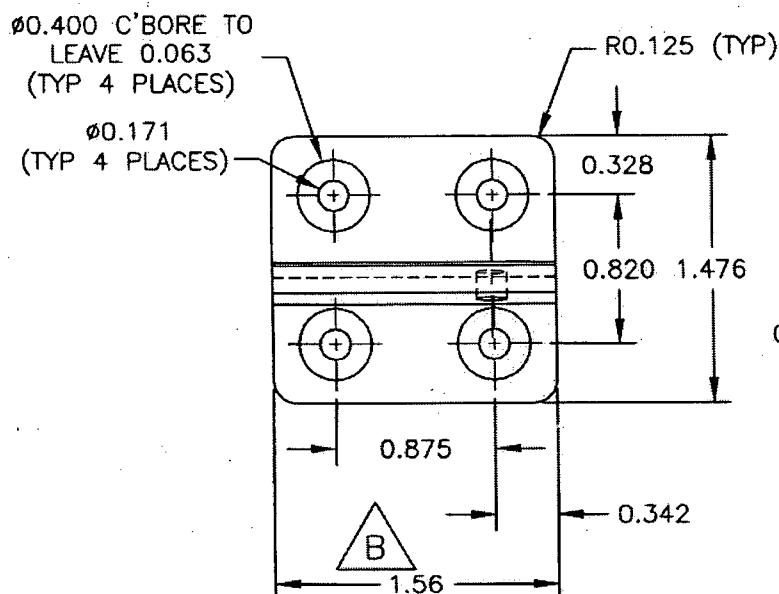
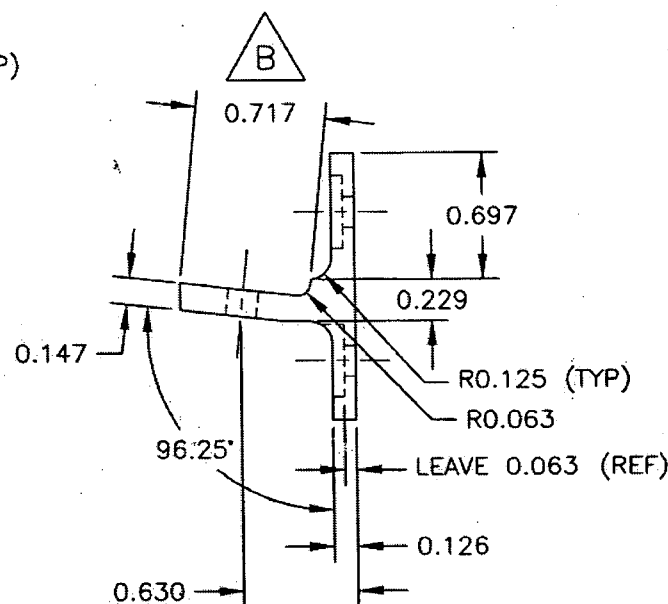
Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	

**DART**



RELEASED  
99.07.03 KE

DESIGN	DATE	CHECKED	APPROVED	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
VE	99.02.28	CP	KE	KE	
DRAWING NO.	TITLE	REV.	SHEET	SCALE	
D2858	HINGE BRACKET	8	1 OF 1	1:1	
	NEW ISSUE				
	0.717 WAS 0.667, 1.56 WAS 1.559				



ENGRAVE P/N CENTERED ON  
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN  
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP (C)  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 28284